Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently Amended) A method of making wet rolls, comprising:

providing a web of material, wherein the web travels at a speed of at least 60 meters per minute;

applying a wetting solution to the web to produce a wet web;

breaking the wet web; and

winding the wet web into a roll.

2. (Original) The method of claim 1, wherein the wetting solution is applied at an add-on greater than about 25%.

3. (Original) The method of claim 1, wherein the wetting solution is applied at an add-on between about 25% and about 700%.

4. (Original) The method of claim 1, wherein the wetting solution is applied at an add-on between about 50% and 400%.

5. (Original) The method of claim 1, wherein the wetting solution is applied at an add-on between about 100% and 350%.

6. (Original) The method of claim 1, wherein the wetting solution is applied at an add-on between about 150% and 300%.

7. (Original) The method of claim 1, wherein the wetting solution is applied at an add-on between about 200% and 250%.

8. Cancelled

9. (Previously Presented) The method of claim 1, wherein the web travels at a speed of at least 80 meters per minute.

10. (Previously Presented) The method of claim 1, wherein the web travels at a speed of at least 150 meters per minute.

11. (Previously Presented) The method of claim 1, wherein the web of material travels at a speed of at least 300 meters per minute.

12. (Previously Presented) The method of claim 1, wherein the roll is coreless.

13. (Previously Presented) The method of claim 1, wherein the web comprises a wet-formed basesheet.

14. (Previously Presented) The method of claim 1, wherein the web comprises a non-woven basesheet.

15. (Previously Presented) The method of claim 1, wherein the web comprises a water-dispersible binder.

16. (Previously Presented) The method of claim 1, wherein the method is performed in an environment which is substantially free of contaminants.

17. (Previously Presented) The method of claim 1, wherein the wetting solution is uniformly distributed in the wet web.

18. (Previously Presented) A method of making wet rolls, comprising:
providing a web of material from a source;
controlling the draw of the web from the source;
perforating the web;
positioning the perforated web adjacent a wetting apparatus;
applying a wetting solution to at least one side of the web with an add-on of at least about 25% to yield a wet web;

breaking the wet web; and

winding the wet web into a roll.

19. (Previously Presented) The method of claim 18, wherein the providing comprises:

obtaining a roll of web material; and

unwinding the roll.

20. (Previously Presented) The method of claim 18, wherein the providing comprises:

combining at least two web plies into a single web.

21. (Previously Presented) The method of claim 18, wherein the providing comprises:

manufacturing a basesheet; and

feeding the basesheet to an apparatus for wetting and winding the web.

22. (Previously Presented) The method of claim 18, wherein the web travels at a speed of at least 60 meters per minute.

23. (Previously Presented) The method of claim 18, wherein the wetting solution comprises salt.

24. (Previously Presented) The method of claim 18, wherein the wetting solution is applied with an add-on between about 25% and about 700%.

25. (Previously Presented) The method of claim 18, wherein the wetting solution is applied at an add-on between about 50% and 400%.

26. (Previously Presented) The method of claim 18, wherein the wetting solution is applied at an add-on between about 100% and 350%.

27. (Previously Presented) The method of claim 18, wherein the wetting solution is applied at an add-on between about 150% and 300%.

28. (Previously Presented) The method of claim 18, wherein the wetting solution is applied at an add-on between about 200% and 250%.

29. (Previously Presented) The method of claim 18, wherein the positioning, applying, and winding are performed in an environment which is substantially free of contamination.

30. (Previously Presented) The method of claim 18, wherein the roll is coreless.

31. (Previously Presented) A method of making a wet coreless roll comprising:

a) providing a wet web of material;

b) breaking the wet web and forming a cigarette from the leading edge of the break;

c) forming a roll of the wet web around the cigarette in a roll forming pocket;

d) separating the wet web roll from the web while repeating step b); and

e) discharging the separated wet web roll from the roll forming pocket.

32. (Previously Presented) The method of claim 31, wherein the roll forming pocket comprises a first roller, a second roller, and a third roller.

33. (Previously Presented) The method of claim 31, wherein the roll forming pocket comprises a first roller, a second roller, and a third roller; the wet web contacting the first roller, the second roller, and the third roller; the first, second and third rollers rotating in the same circular direction; and the second roller rotating in a circular direction opposite from the direction of movement of the wet web.

34. (Previously Presented) The method of claim 31, further comprising perforating the web.

35. (Previously Presented) The method of claim 34, further comprising making the break of step b) along a line of perforation.

36. (Previously Presented) The method of claim 31, wherein the method is performed in an environment which is substantially free of contaminants.

37. (Previously Presented) The method of claim 31, wherein the web travels at a speed of at least 60 meters per minute.

38. (Previously Presented) The method of claim 31, wherein the wet web comprises an add-on of a wetting solution of at least about 25%.

39. (Previously Presented) A method of making wet coreless rolls comprising:

providing a wet web;

breaking the wet web;

winding the wet web into a roll using a roll forming pocket;

the roll forming pocket comprising a first roller, a second roller and a third roller; the wet web contacting the first roller, the second roller, and the third roller; the first, second and third rollers rotating in the same direction; and the second roller rotating in a direction opposite from the direction of movement of the wet web; and

discharging the wet web roll from the roll forming pocket.

40. (Previously Presented) The method of claim 39, wherein the wet web is made by applying a wetting solution to a basesheet.

41. (Previously Presented) The method of claim 40, wherein the wetting solution is applied at an add-on greater than about 25%.

42. (Previously Presented) The method of claim 40, wherein the wetting solution is applied at an add-on between about 25% and about 700%.

43. (Previously Presented) The method of claim 40, wherein the wetting solution is applied at an add-on between about 50% and 400%.

44. (Previously Presented) The method of claim 40, wherein the wetting solution is applied at an add-on between about 100% and 350%.

45. (Previously Presented) The method of claim 40, wherein the wetting solution is applied at an add-on between about 150% and 300%.

46. (Previously Presented) The method of claim 40, wherein the wetting solution is applied at an add-on between about 200% and 250%.

47. (Previously Presented) The method of claim 40, wherein the wetting solution comprises salt.

48. (Previously Presented) The method of claim 39, wherein the method is performed in an environment which is substantially free of contaminants.

49. (Withdrawn) An apparatus for wetting and winding a substrate, comprising:

means for applying a wetting solution to the substrate to form a wet substrate; and

means for winding coreless rolls of the wet substrate.

50. (Withdrawn) The apparatus of claim 49, further comprising a means for perforating the substrate.

51. (Withdrawn) The apparatus of claim 49, wherein the means for applying a wetting solution distributes the wetting solution evenly along the substrate.

52. (Withdrawn) The apparatus of claim 49, wherein the means for applying a wetting solution comprises a means for increasing the absorption rate of the solution in the substrate.

53. (Withdrawn) The apparatus of claim 49, wherein the wetting solution is present in the wet substrate in an add-on of at least about 25%.

54. (Withdrawn) The apparatus of claim 49, wherein the apparatus is in an environment which is substantially free of contaminants.

55. (Withdrawn) An apparatus for wetting and winding a substrate, comprising:

a wetting apparatus; and

a wining apparatus;

wherein the winding apparatus can form wet coreless rolls with an add-on of at least about 25%.

56. (Withdrawn) The apparatus of claim 55, further comprising a perforating apparatus.

57. (Withdrawn) The apparatus of claim 55, wherein the wetting apparatus is a fluid distribution header.

58. (Withdrawn) The apparatus of claim 55, wherein the wetting apparatus is a spray boom.

59. (Withdrawn) The apparatus of claim 55, wherein the wetting apparatus comprises a drool bar.

60. (Withdrawn) The apparatus of claim 55, wherein the wetting apparatus comprises press rolls.

61. (Withdrawn) The apparatus of claim 55, further comprising a detour roller.

62. (Withdrawn) The apparatus of claim 55, wherein the winding apparatus comprises an upper winding roller, a lower winding roller, a rider roller and a transfer shoe.